

Appl. No. 09/852,267
Response filed on December 4, 2002

A) supplementing the molten metal in the feeder head to the cavity when the molten metal in the cavity is solidified and shrunked.

A2 4. (Amended) The method according to claim 1,
wherein an inner face of the feeder head is coated with heat insulating lubricant,
and
an inner face of the cavity is free of heat insulating lubricant.
